

Work Order ID 157530

Friday, March 10, 2017 4:07:06 PM

157530

Page 1

Item ID: D412-704-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cable Assembly

Start Date: 3/16/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/23/2017 Req'd Qty: 1.00

1

Customer:

Reference: SCHEDULED/S

Approvals: Process Plan:

Date:

MAR 10 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9611	A ✓								
IIN D412-704	CE ✓								
100	Small Fab	0.00							
100	Small Fab					1	FF	MAR 13 2017	
	Memo	0.03							
	Assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
110	QC					1			
	Memo	0.00							
	Quality Control								

DAS
38
9-89

MAR 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

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N900040100

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Customer:

Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <i>5215</i>	0.00					<i>AS</i>		
120							<i>5</i>	MAR 13 2017	
Packaging	Memo	0.00					<i>19</i>		
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.02							
Quality Control									

DAS
21
9-89

MAR 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Picklist Print

Friday, March 10, 2017 4:07:12 PM

Page 1

Work Order ID: 157530

157530

Parent Item: D412-704-045

D412-704-045

Parent Item Name: Cable Assembly

Start Date: 3/16/2017

Required Date: 3/23/2017

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B05.01.28 Added Figures 1-2KJ/RF

IPP Rev:C 08-10-08 as per revB DD verified by:EC

IPP REV:D

12.05.10 per DSI 9611 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-10A

Purchased

No

100

Each

174.0000

1

1

AN3-10A

Bolt

**

FF

MAR 13 2017

Location

Loc Qty

Loc Code

GA

64

m136787

64

over003

100

m136665

100

ST349

10

m136192

10

AN3-5A

Purchased

No

100

Each

490.0000

1

1

AN3-5A

Bolt

**

FF

MAR 13 2017

Location

Loc Qty

Loc Code

ST350

490

m136182

190

m136986

300

D3217-3

Manufactured

No

100

Each

5.0000

1

1

D3217-3

Cable 80.5"

**

FF

MAR 13 2017

Location

Loc Qty

Loc Code

ST217

5

148029

5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
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				Lead hand / Supervisor Approval Verification	
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OTHER : ☐					

Picklist Print

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Parent Item: D412-704-045

D412-704-045

Parent Item Name: Cable Assembly

Start Date: 3/16/2017

Required Date: 3/23/2017

Start Qty: 1.00

Required Qty: 1.00

D3257-1

Manufactured No

100

Each

3.0000

1

1

D3257-1

Fitting

FF

MAR 13 2017

Location

Loc Qty

Loc Code

ST028

3

152853

3

1

D3258-1

Manufactured No

100

Each

6.0000

1

1

D3258-1

Angle Bracket

FF

MAR 13 2017

Location

Loc Qty

Loc Code

ST028

6

152832

6

1

MS21042L3

Purchased No

100

Each

1,354.000

2

2

MS21042L3

Nut

FF

MAR 13 2017

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

224

m134360

102

M136665

122

2

OVER007

300

m134360

0

M136665

300

ST303

730

M136554

500

M136838

230

DQA: _____ Date: _____



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Work Order update only ☐

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Friday, March 10, 2017 4:07:12 PM

Page 3

Work Order ID: 157530

157530

Parent Item: D412-704-045

D412-704-045

Parent Item Name: Cable Assembly

Start Date: 3/16/2017

Required Date: 3/23/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

100

Each

978.0000

2

2

NAS1149D0332.J

FF

MAR 13 2017

Washer

Location

Loc Qty

Loc Code

GA

536

m136643

536

2

ST264

442

m136015

442

NAS1149D0363J

Purchased

No

100

Each

649.0000

2

2

NAS1149D0363.J

FF

MAR 13 2017

Washer

Location

Loc Qty

Loc Code

GA

161

m134055

161

2

ST263

488

m136781

488

NAS509-3

Purchased

No

100

Each

22.0000

3

3

NAS509-3

FF

MAR 13 2017

Nut

Location

Loc Qty

Loc Code

ST551

22

M136047

6

3

M136986

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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